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Fax 613 632-5246

RBE117-12010W66
Job Sheet 185126



7154
Dec 7

Part No: RBE117-12010W66

Job Qty: 4 ea

Part Name: Guard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-12010W66 Rev. 1 IPP Rev. A 18.09.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/30/18	0.00	0.00	Start Up Small Fab-2		7/10
110	Small Fab	4 pcs		11/30/18	0.00	4.00	Small Fab-3		MU DAS
120	QC	4 pcs		11/30/18	0.00	0.00	QC5		30
130	Packaging	4 pcs		11/30/18	0.00	0.00	Packaging3-1		9-89
140	QC21-FG	4 Ea		11/30/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

DEC 21 2018

GA 162

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92000A439	Machine Screw Phillips M6 X 1 X 35mm	4 Ea (1 ea)	90-Start up Operation	5116843
93475A250	Washer M6	4 Ea (1 ea)	90-Start up Operation	5116854
98381A107	Dowel Pin Ø3/16 X 11/16	8 Ea (2 ea)	90-Start up Operation	5116838
RBE117-12010W66-1	Ring 1	4 Ea (1 ea)	110-Small Fab	5134228
RBE117-12010W66-3	Ring 2	4 Ea (1 ea)	110-Small Fab	5135228
RBE117-12010W66-5	Ring Link	4 Ea (1 ea)	110-Small Fab	5124362
RBE117-12010W66-7	Hinge Block	4 Ea (1 ea)	110-Small Fab	5128877

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	92000A439	4	25	0
	93475A250	4	100	0
	98381A107	8	20	0
110-Small Fab	RBE117-12010W66-1	4	0	0
	RBE117-12010W66-3	4	0	0
	RBE117-12010W66-5	4	0	0
	RBE117-12010W66-7	4	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

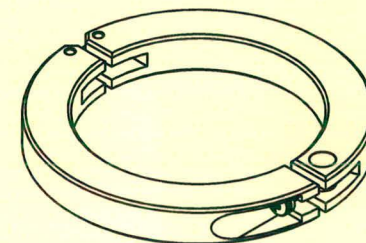
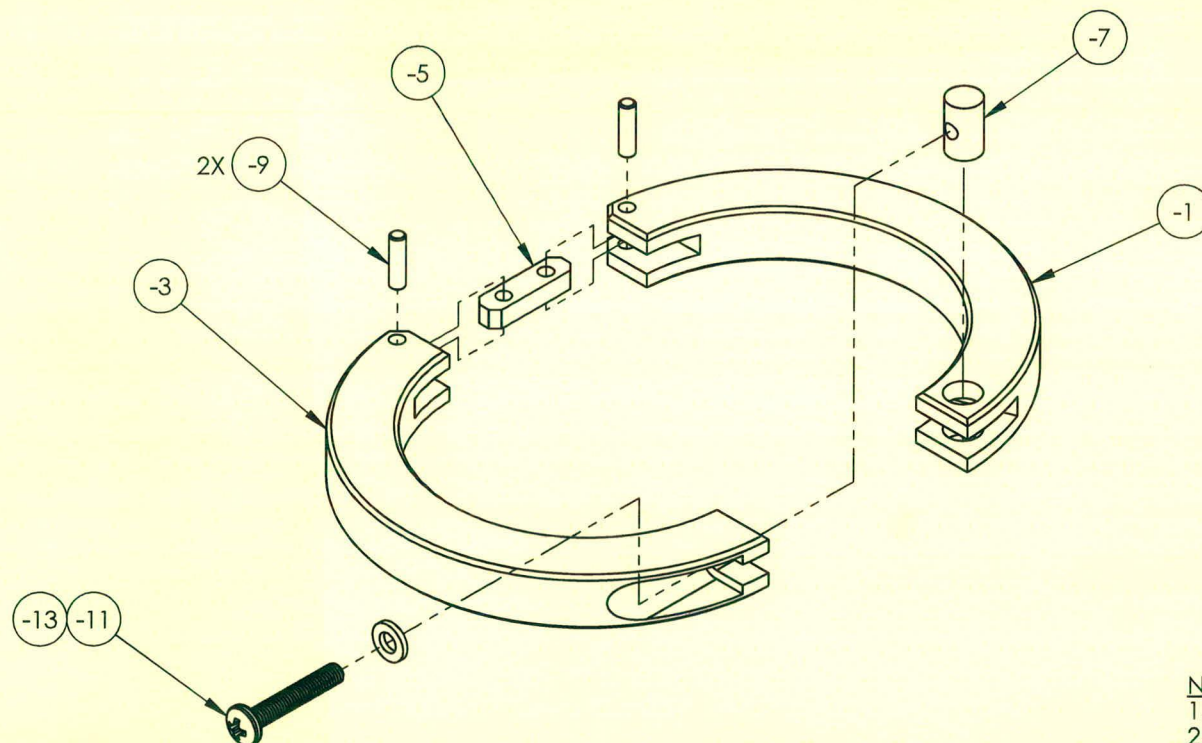
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube</td> <td style="width: 15%;">Cross tube</td> <td style="width: 15%;">Water Jet</td> <td style="width: 15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Thermoforming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Large Fab</td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
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Thermoforming	Finishing	Rec/Store/Packaging	Other																						
Large Fab	Composite	Supplier																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

Root Cause				FAULT CATEGORY			
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong		
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions		
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance		
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect		
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing		
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved		
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing		
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish		
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread		
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence		
Past Expiry Date	Manufacturing Process	OTHER : _____					
Misidentified	Past Due						

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	4/22/2016	SM	JAG



SHOP COPY
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 185126 MLW
18-10-23

- NOTES:
1. REF. EUROCOPTER T/N: 117-12010W66.
2. PART OF KIT RBE117-12010W62.

DART AEROSPACE																																	
TITLE GUARD																																	
DWG NO. RBE117-12010W66	REV 1																																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>TREAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>SPEC</td> <td>.X ± .1 SURFACES = 125/✓</td> </tr> <tr> <td>DRAWN BY:</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED:</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR:</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR:</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED:</td> <td>3. INTERPRET DIM AND TOL PER</td> </tr> <tr> <td></td> <td>ASME Y14.5M-2009</td> </tr> <tr> <td></td> <td>USED ON MODEL</td> </tr> <tr> <td></td> <td>EC 145</td> </tr> <tr> <td>SCALE</td> <td>DATE</td> </tr> <tr> <td>1:2</td> <td>2/23/2016</td> </tr> <tr> <td></td> <td>SHEET 1 OF 5</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT	DIMENSIONS ARE IN INCHES	TREAT	.XXX ± .005 FRACTIONS ± 1/8	FINISH	.XX ± .01 ANGLES ± 5°	SPEC	.X ± .1 SURFACES = 125/✓	DRAWN BY:	1. BREAK ALL SHARP EDGES	CHECKED:	.015 x 45° OR .015R	OPPS APPR:	2. DIMENSIONAL LIMITS APPLY	QA APPR:	AFTER PLATING	APPROVED:	3. INTERPRET DIM AND TOL PER		ASME Y14.5M-2009		USED ON MODEL		EC 145	SCALE	DATE	1:2	2/23/2016		SHEET 1 OF 5
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RING 1	6061		2
			-3	1	RING 2	6061		3
			-5	1	RING LINK	1018/1020 CR		4
			-7	1	HINGE BLOCK	1018/1020 CR		5
		B/O	-9	2	DOWEL PIN	STEEL	Ø3/16 X 11/16 (MCMASTER-CARR # 98381A107)	1
		B/O	-11	1	MACHINE SCREW	S.S.	PHILLIPS M6 X 1 X 35MM (MCMASTER-CARR # 92000A439)	1
		B/O	-13	1	WASHER	S.S.	M6 (MCMASTER-CARR # 93475A250)	1



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Container No: S139259



Part: RBE117-12010W66

Job No: 185126

Serial No/Batch: S139259

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/20/18